

*DUPLICATE*

**Dart Aerospace Ltd.**

Date: Tuesday, 22/05/2007 11:31:11 AM  
User: Linda Lacelle

### Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HOUSING WELDMENT
<b>Job Number</b> : 32219	
<b>Estimate Number</b> : 11874	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D2207041
<b>This Issue</b> : 22/05/2007 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : D2207 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 03/05/2007 <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : C
<b>Previous Run</b> : <i>N/A</i>	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 10/05/2007
<b>Checked &amp; Approved By</b> : <i>[Signature]</i>	<b>Qty:</b> <i>6</i> <b>Um:</b> Each
<b>Comment</b> : Est. C 01.10.18 Added Step 10 and 11 SM	

#### Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D2208	End Cap
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

End Cap

Pick:

Qty	Part Number	Description
2	D2208	End cap

Batch

*13261 x4 4510 x8 FC 07 05 23 (6)*

2.0	D22071	Housing
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Housing

Pick:

Qty	Part Number	Description
1	D2207-1	Housing

Batch

*15242 FC 07 05 23 (6)*

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

Weld as per Dwg D2207

Grind welds flush as per Dwg D2207

*Ph. FC*

*07.05.23*

*07 05 23*

*(6)*

4.0	QC9	VISUAL WELDING INSPECTION
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**Comment:** VISUAL WELDING INSPECTION

*107/05/24 (6)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070824	3.0	Parts were made to Rev. B. No gage, and weld crack	DS1412	Scrap, destroy, no replace. Another W/O was issued at rev. C. B33982 → see W/O	Am 07/08/27	07/08/27	DS1412	070824

NOTE: Date & initial all entries

Date: Tuesday, 22/05/2007 11:31:11 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOUSING WELDMENT

Job Number: 32219

Part Number: D2207041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Drill holes using DT8557 as per Dwg D2207

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

ALS71032130

Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Insert

Qty Part Number Description Batch

4 DAK57-1032-130 Insert

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Install AK57-1032-130 as per Dwg D2207

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 22/05/2007 11:31:11 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOUSING WELDMENT

Job Number: 32219

Part Number: D2207041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

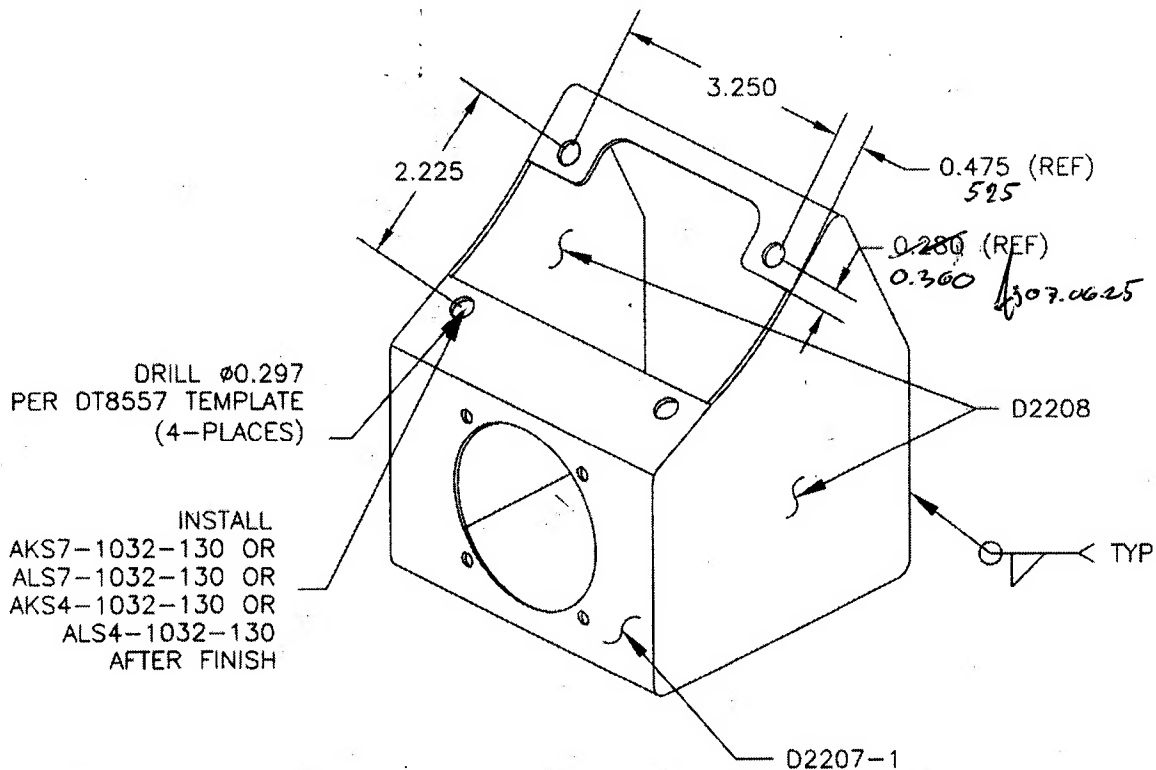
NOTE: Date & initial all entries

Total: 3.775  
(3.250 + .525)

3.775

SIGN KF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED J	APPROVED S	DRAWING NO. D2207	REV. B SHEET 1 OF 2
DATE 01.02.23	TITLE HOUSING		SCALE 1:2
	94.09.01	NEW ISSUE	
	01.02.23	REDRAWN	

Wp 32249



D2207-041 ASSEMBLY

2208  
2207-1

NOTE:

- 1) WELD PER DART QSI 004
- 2) GRIND WELDS FLUSH
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT CLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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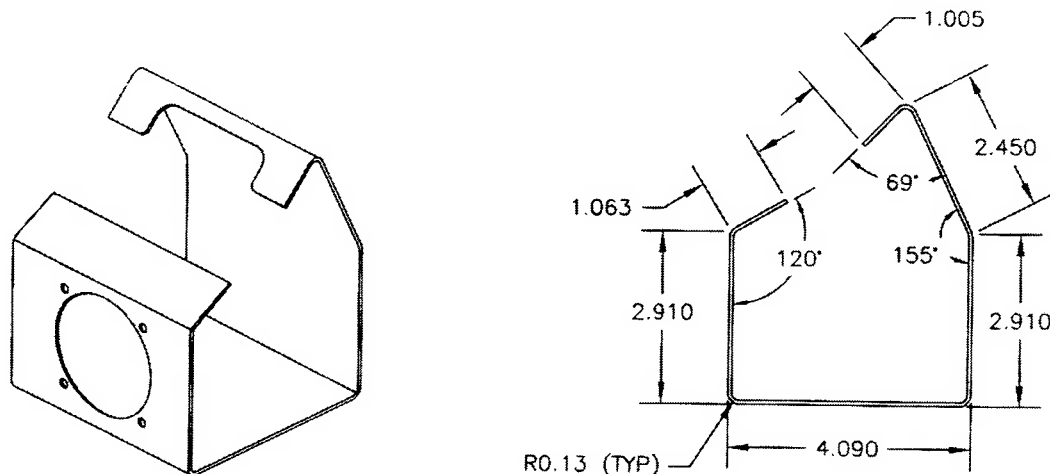
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**DART**

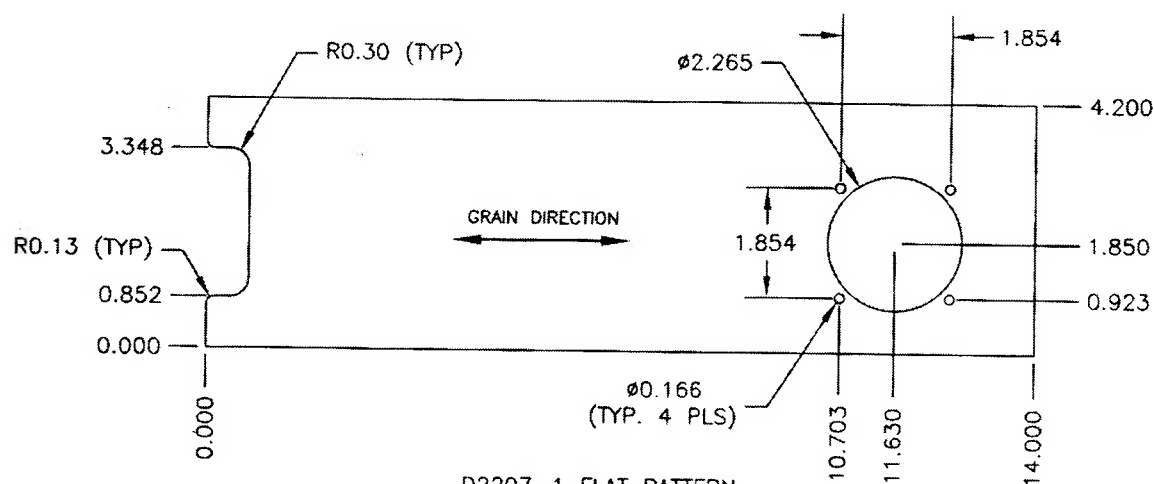


DESIGN	RF	DRAWN BY	RF	<b>DART AEROSPACE LTD</b>
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	01.02.23	TITLE	D2207	REV. B
		HOUSING		SHEET 2 OF 2
				SCALE 1:3

**RELEASED**  
07.27



D2207-1 BENDING DETAIL



D2207-1 FLAT PATTERN

MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) ALUMINUM 0.063 THICK  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED